

# Work Order ID 75608

**\*75608\***

Page 1

October-26-11 2:22:06 PM

Item ID: D206-581-013

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Pre-Flight Step Installation, LH

Start Date: 10/26/11 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/27/11 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D206-581

C

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD206-581-013

CHG001

W 11 - 11 - 04 ①  
J Gar MLT 11-10-27 ①

110

Pick Kit

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

SP 11 - 10 - 27

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

Memo

0.00

Quality Control

W 11 - 11 - 04 ①

**Work Order ID 75608****\*75608\***

Page 2

Item ID: D206-581-013

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Pre-Flight Step Installation, LH

Start Date: 10/26/11 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 10/27/11 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-581-013								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

11/11/8

MF

11-10-07

October-26-11 2:22:05 PM

**Required Qty: 1.00**

**Comments:** Ipp Rev:A New Issue 10-07-16 JLM Verified BY:DD

116513	3
--------	---

5.0 PART LIST

5.1 D407-581-111/-011 AND D206-581-113/-013/-014/-015/-017 KITS

Qty -111	Qty -113	Qty -011	Qty -013	Qty -014	Qty -015	Qty -017	Part Number	Description
X							D407-581-111	PRE-FLIGHT KIT (407)
	X						D206-581-113	PRE-FLIGHT KIT (206A/B/L/L1/L3/L4)
2		X					D407-581-011	PRE-FLIGHT STEP KIT, LH/RH (407)
	1		X				D206-581-013	PRE-FLIGHT STEP KIT, LH (206A/B/L/L1/L3/L4)
	1			X			D206-581-014	PRE-FLIGHT STEP KIT, RH (206A/B/L/L1/L3/L4)
4	4				X		D206-581-015	STEP HANDLE KIT
						X	D206-581-017	RETENTION STRAP KIT
						2	D3031-3	LOOP
		1	1	1			D4101-041	PRE-FLIGHT STEP ASSEMBLY
			1				D4102-1	SHIM (206 LH)
				1			D4102-2	SHIM (206 RH)
		1					D4102-3	SHIM (407)
					1		D4103-1	STEP HANDLE
						1	D4104-041	DOUBLER ASSEMBLY
						1	D4105-1	STRAP
						2	80-004-2D8	INSERT
					2		80-005-3-8	INSERT
		6	6	6			80-005-3-16	INSERT
						8	CR3243-4-1	RIVET
						2	MS21042L3	NUT
						2	MS24694-S47	SCREW
						2	MS24694-S50	SCREW
						2	MS24694-S52	SCREW
					2		MS27039-4-11	SCREW
		6	6	6			MS27039-4-14	SCREW
						2	NAS1149D0332J	WASHER (or AN960JD10L)
		6	6	6	2		NAS1149D0416J	WASHER (or AN960JD416L)
					2		NAS1149D0463J	WASHER (or AN960JD416)